

Asst please @

# Work Order ID 62409

September 29, 2010 12:51:37 PM

Page 1

Item ID: D3561-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Seal Insert Tool

Start Date: 9/29/10 Start Qty: 10.00

Cust Item ID:

Required Date: 10/01/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3561

Rev A

- 100

0.00

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3561 1-Dwg Rev: A : Prog Rev: A 2-  
Deburr if necessary

B10-9-09

(14)

304 .126

110

QC2- Inspect parts off machine FAI/FAIB

0.00

B10-9-09

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

14

1009-30

QC

Memo

0.00

Quality Control

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

N/A

140

NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3561

EB 12/20/01

14

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/10/10/01

44

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: 67

0.00

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/1/10 14

10/10/04

MF 10-10-04

# Picklist Print

September 29, 2010 12:51:36 PM

Page 1

Work Order ID: 62409

Parent Item: D3561-1

Parent Item Name: Seal Insert Tool

Start Date: 9/29/10

Required Date: 10/01/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: A 06.10.19 New issue (EC)

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S11GA                       |                        | Purchased     | No          |                     |                  | 100             | sf                 | 63.9423        | 0.0473      | 0.497895     | 167           |                |        |

304/316 0.125 Sheet

1810-9-09

Location

Loc Qty

Loc Code

MAT

63.9423

114799

63.9423

114799

(14)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

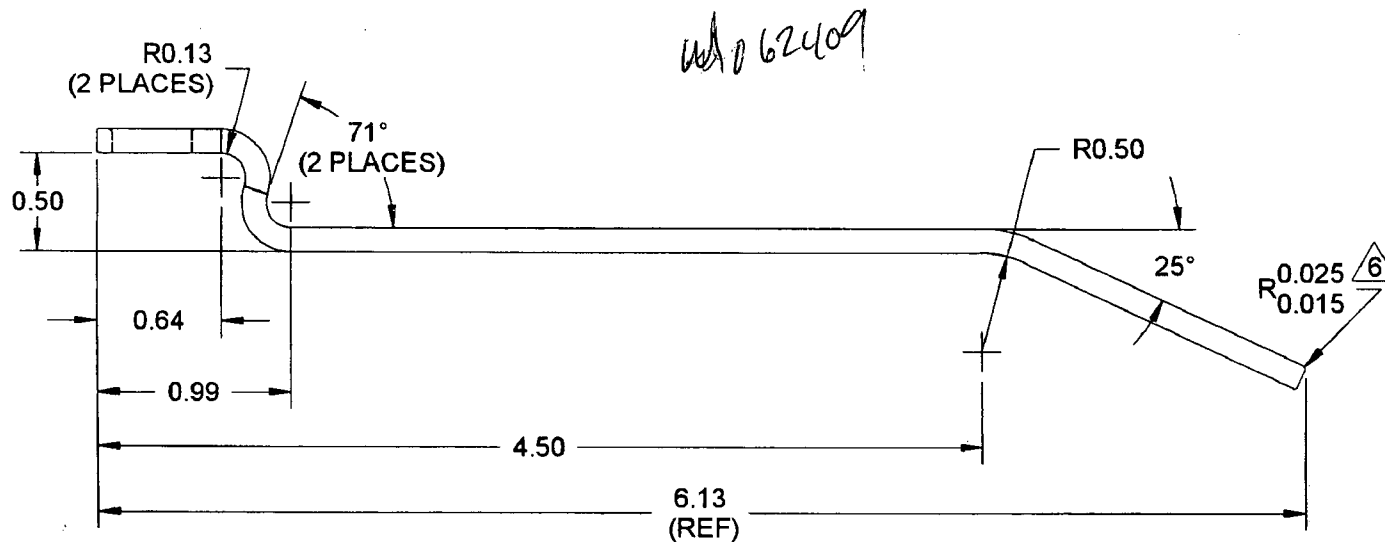
**NOTE:** Date & initial all entries





|         |          |          |   |              |
|---------|----------|----------|---|--------------|
| DESIGN  |          | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |              |
| CHECKED | PH       | APPROVED | DRAWING NO.                                       | REV. A       |
| DATE    | 06.10.06 |          | D3561   | SHEET 1 OF 1 |
| REV.    | A        | DATE     | TITLE   | SCALE        |
|         |          | 06.10.06 | SEAL INSERT TOOL                                  | 1:1          |
|         |          | 06.10.06 | NEW ISSUE   |              |

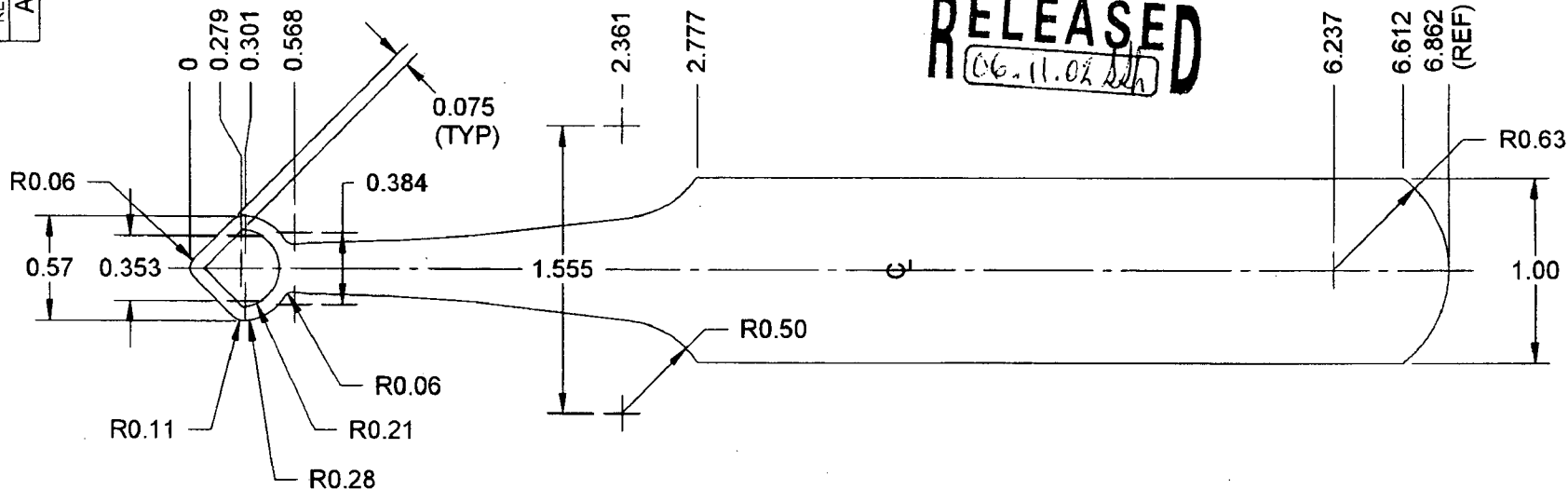
**DART**



### D3561-1 SEAL INSERT TOOL

#### NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK, PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S10GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP CORNERS 0.015 TO 0.025



### D3561-1F SEAL INSERT TOOL FLAT PATTERN

**RELEASED**  
06.11.02